

Date: Thursday, 9/14/2006 7:28:32 AM
 User: Kim Johnston

Process Sheet

Split
SB 06/10/05

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE ASSEMBLY
Job Number : 28556	
Estimate Number : 12183	
P.O. Number : <i>N/A</i>	Part Number : D3469043
This Issue : 9/14/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3469 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 26985	Material : <i>N/A</i>
Written By : _____	Due Date : 10/6/2006 Qty: 4 Um: Each
Checked & Approved By : <i>06 09 14</i>	
Comment : Est Rev: A New Issue 06-02-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34691	TUBE
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D3469-1	Tube	<i>B 27012</i>
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2.0	D34695	LOWER PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

LOWER PLATE

Batch: *B 28371-1* *B 29059*

3.0	AN960C416L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

4	AN960C416L	Washer	<i>M100651</i>
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4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3469 Using Dt8849 Assembly Jig, Use 1/4" Shaft To Align Butterfly Shaft holes

M.F. 06-11-08

2-Spot Weld as per Dwg D3469 and Dart QSI 018

M.F. 06-11-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 06/11/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:28:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 28556

Part Number: D3469043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

SB 06/11/09 (4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ST350 RB 06/11/09 (1)

POOK

SB 06/11/09 (3)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/10 (3)

Job Completion



06/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

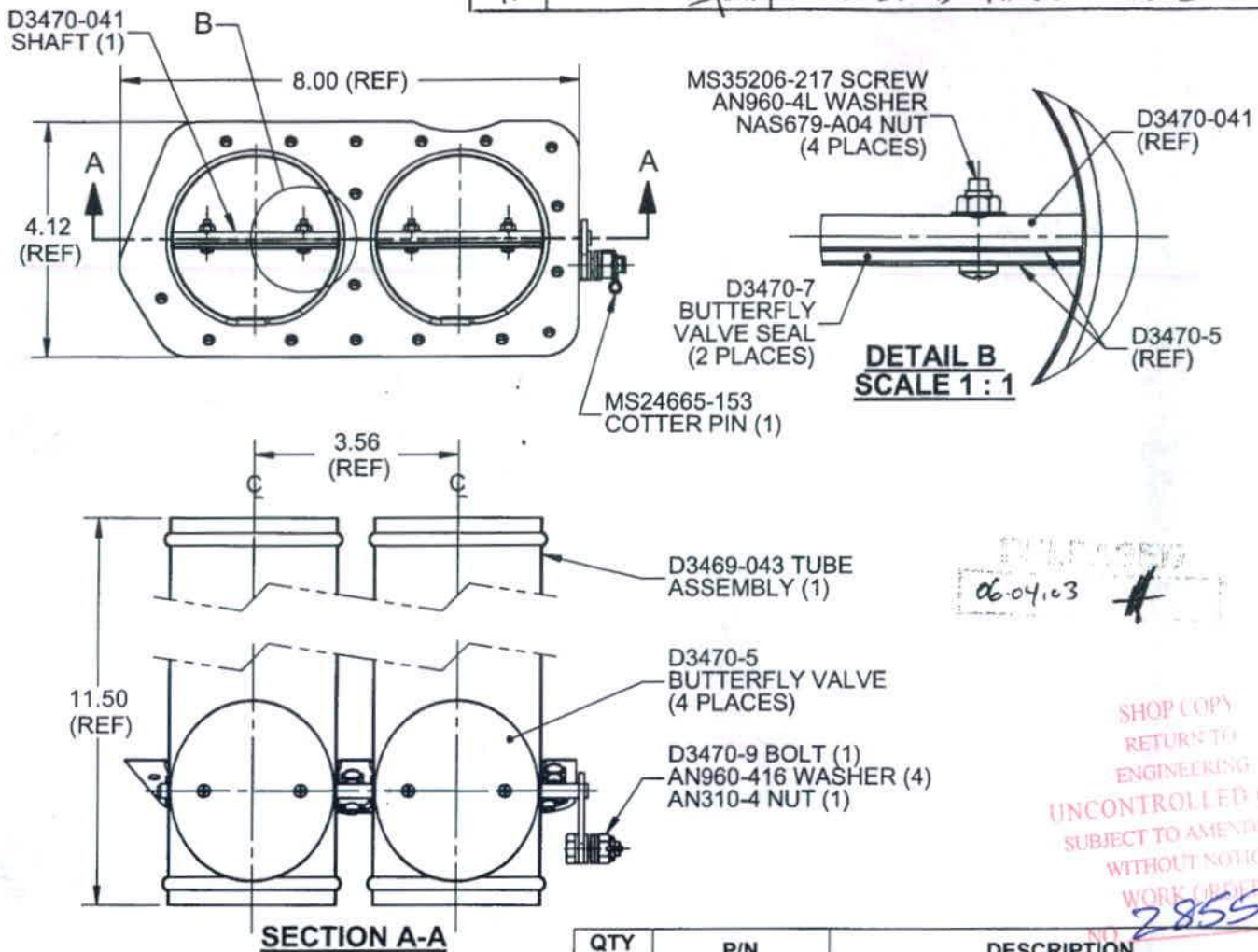
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3469	REV. A SHEET 1 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:3
A	05.12.12	NEW ISSUE	
A1	06.04.20	CORRECTED B.O.M. ON PAGE 2	

**D3469-041 SHUT-OFF VALVE ASS'Y****NOTES:**

- 1) IDENTIFY WITH DART P/N D3469-041 USING FINE POINT PERMANENT INK MARKER
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

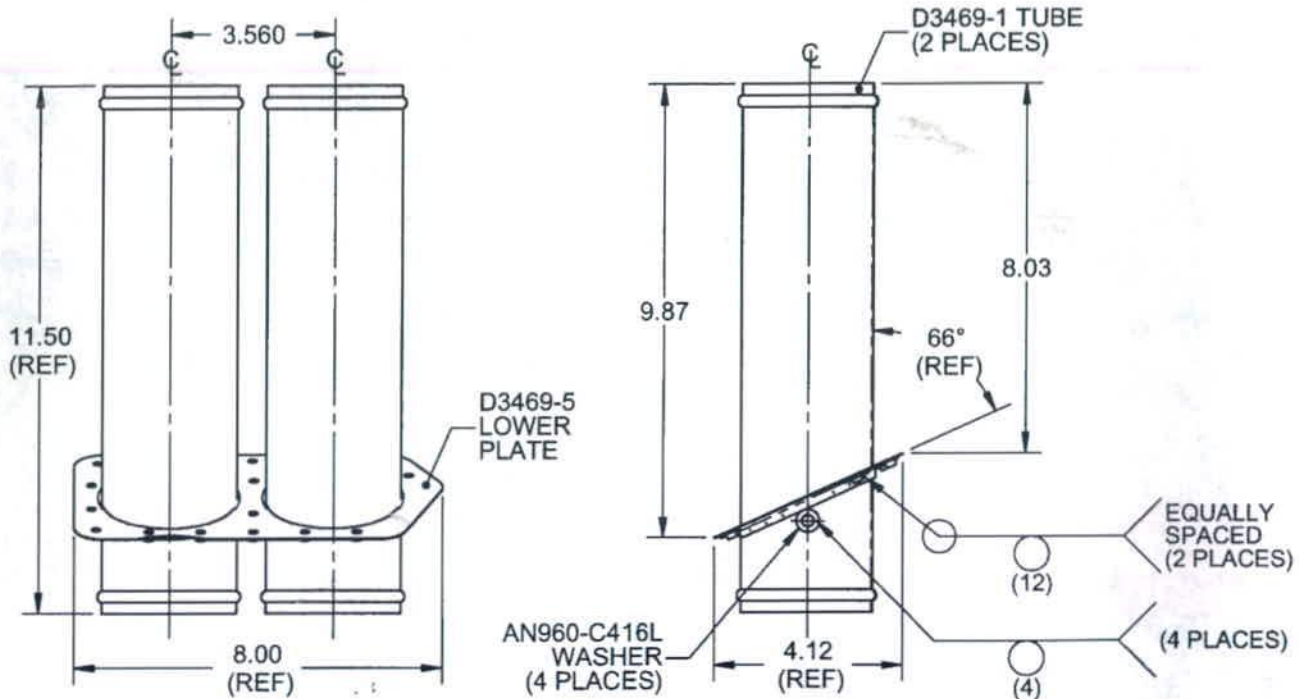
QTY -041	P/N	DESCRIPTION
X	D3469-041	SHUT-OFF VALVE ASSEMBLY
1	D3469-043	TUBE ASSEMBLY
1	D3470-041	SHUT-OFF VALVE SHAFT
4	D3470-5	BUTTERFLY VALVE
2	D3470-7	BUTTERFLY VALVE SEAL
1	D3470-9	BOLT
1	AN310-4	NUT
4	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
4	MS35206-217	SCREW
4	NAS679-A04	NUT

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DART

DESIGN #B	DRAWN BY #B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #H	APPROVED #H	DRAWING NO. D3469	REV. A SHEET 2 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4




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WITHOUT NOTICE
WORK ORDER
28576

D3469-043 TUBE ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

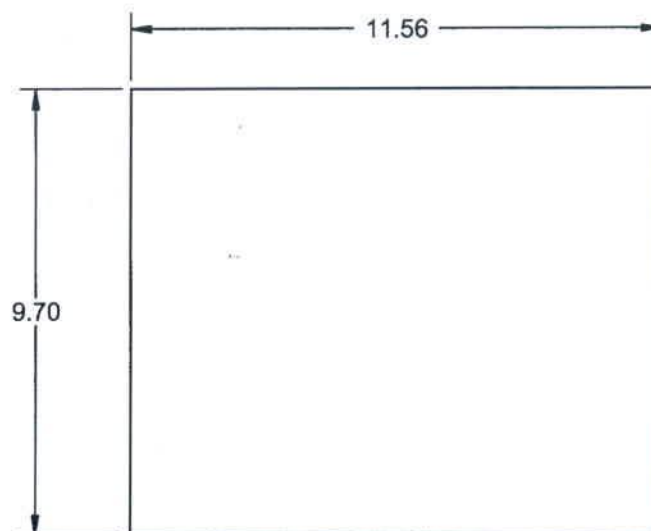
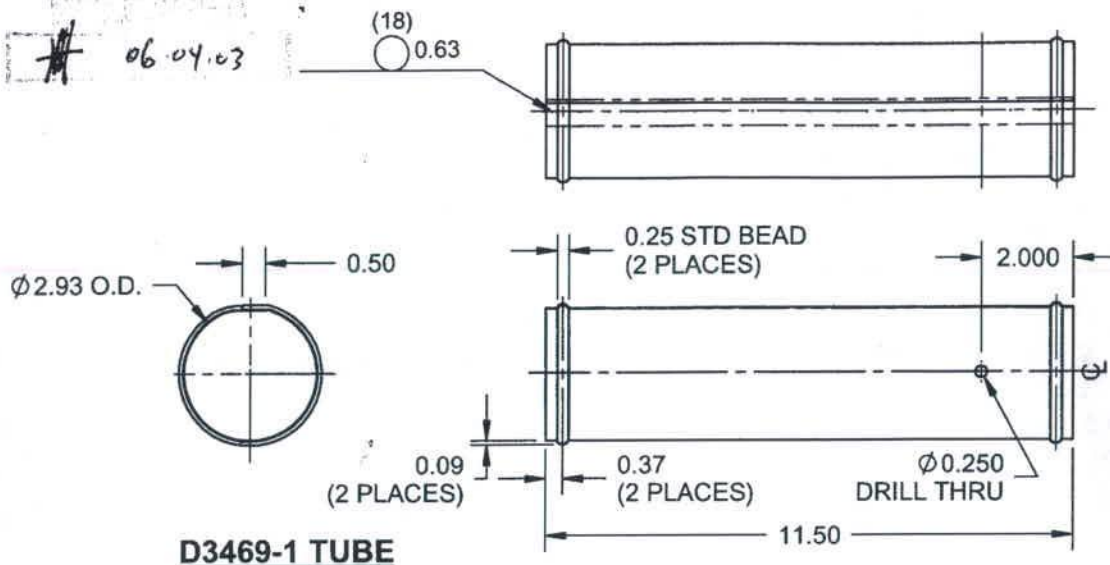
QTY -043	P/N	DESCRIPTION
X	D3469-043	TUBE ASSEMBLY
2	D3469-1	TUBE
1	D3469-5	LOWER PLATE
4	D3470-5	PLATE VALVE 
4	AN960-C416L	WASHER

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3469	REV. A SHEET 3 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4



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NOTES:

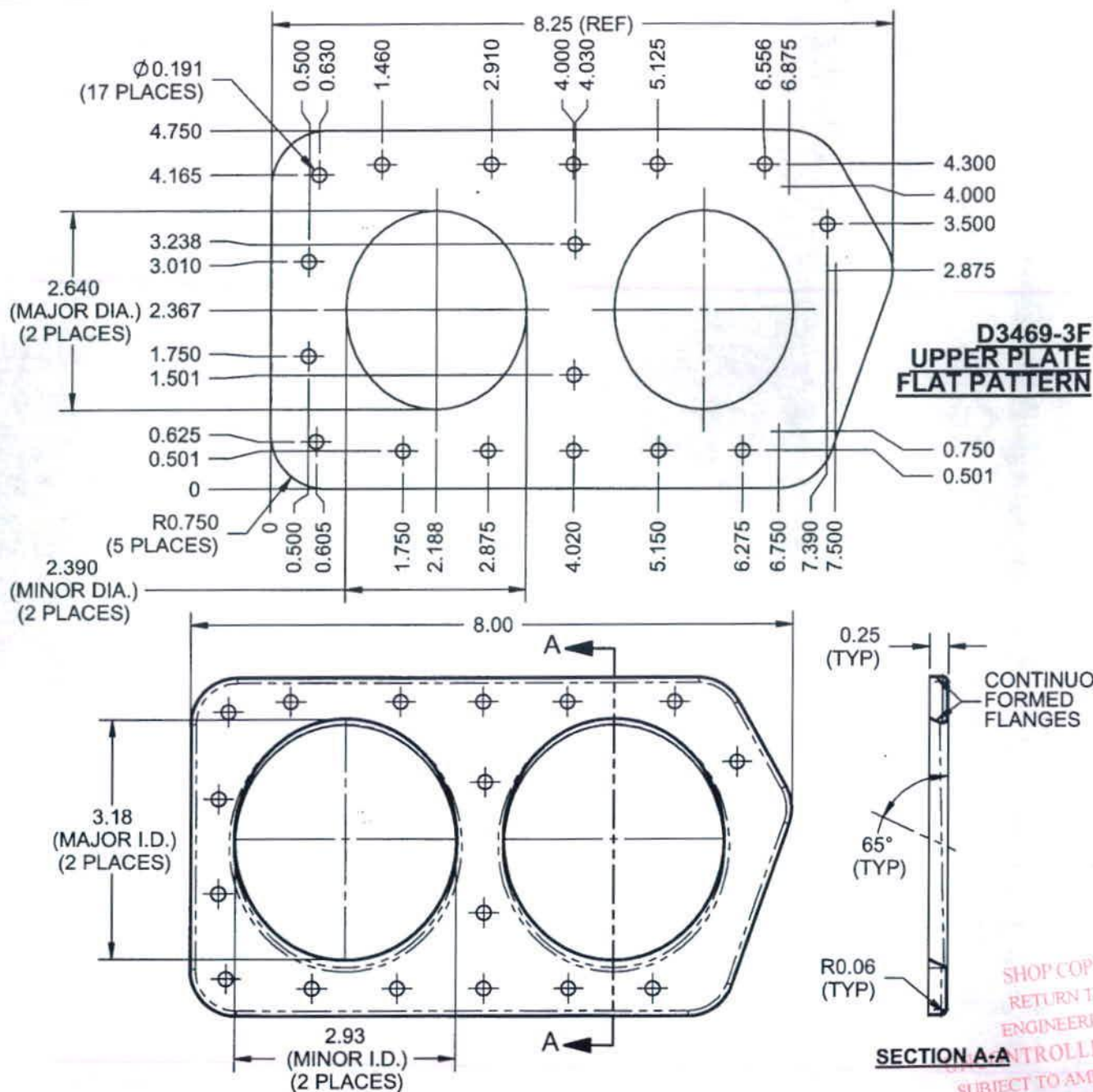
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3469	REV. A SHEET 4 OF 5
DATE 05.12.12	TITLE SHUT-OFF VALVE ASS'Y		SCALE 1:2

**D3469-3 UPPER PLATE BENDING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: NONE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

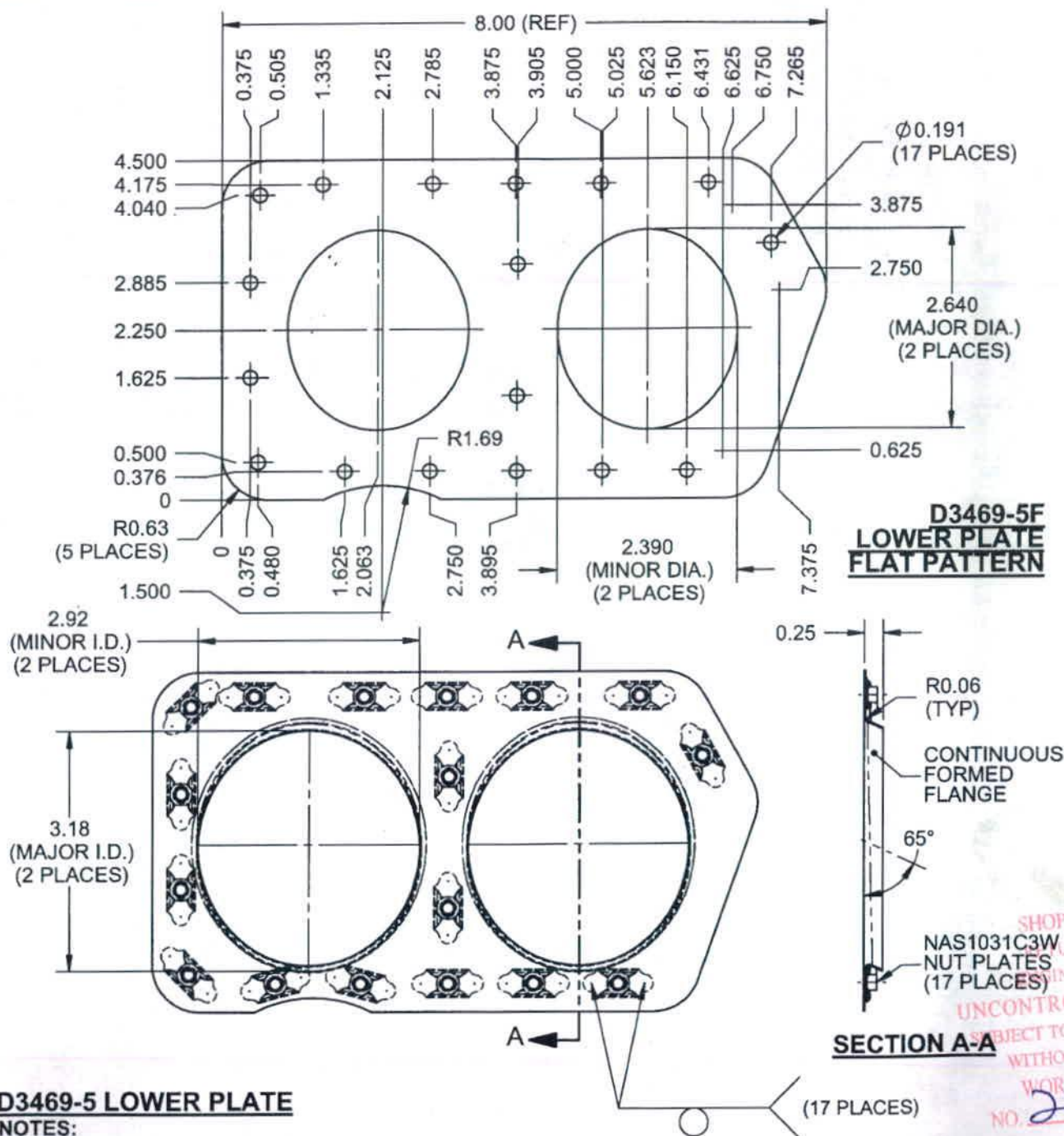
06-07-03

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DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3469	REV. A SHEET 5 OF 5
DATE 05.12.12	TITLE SHUT-OFF VALVE ASS'Y		SCALE 1:2

**D3469-5 LOWER PLATE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD NUT PLATES PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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06.04.03

SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 8

EMPLOYEE: Melanie Fautert

PART NUMBER: D3469-043

JOB NUMBER: B28556

MATERIAL TYPE: 304/316

MATERIAL THICKNESS: .018

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☒

Group 2: Iron; nickel; cobalt

☐

Group 3: Titanium

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 06/11/03
QUALIFIER: Sylvia Boucher

